

Date: Friday, 05/09/2008 7:13:25 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT LH		
Job Number	: 41851			Part Number	: D32813		
Estimate Number	: 11228			Drawing Number	: D3281 REV. D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 05/09/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 12/09/2008		
Previous Run	: 40474			Qty:	3		
Written By	:			Um:	Each		
Checked & Approved By	:						
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
Comment: Qty.: 4.3330 sf(s)/Unit Total : 21.6650 sf(s) GE PLASTICS LEXAN SHEET		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 41851

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/09/08 X3

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

BB 08/09/08 X3

2) Check dimensions to ensure conformity to drawing tolerances.

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/08 X3

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST273 08/09/10 X3

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10 X3

Job Completion



mf 08-09-10

DART AEROSPACE LTD	Work Order:	41851
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: B3

Date: 08/09/08

TRIMMING SECTION

Measured by: B

Date: 08/09/08

Audited by: 

Date: 08/09/08

Prototype Approval:

NA

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	<i>[Signature]</i>
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	41851
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than .1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
				/ /

Measured by: BB

Date: 08/09/09

TRIMMING SECTION

Measured by:

Date: 08/09/09

Audited by:

Date: 8/20/09

Prototype Approval:

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

DART AEROSPACE LTD	Work Order:	41851
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 08/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75	✓			
17.1	+/-0.100	17.11	✓			
14.3	+/-0.100	14.27	✓			
0.95	+/-0.030	.960	✓			
0.25	+/-0.030	.245	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	.094	✓			
0.070	+/-0.010	.125	✓			
		Min.				

Measured by: *BB*

Date: 08/09/09

Audited by: *S*

Date: 08/09/09

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>BB</i>	<i>BB</i>